[illegible]

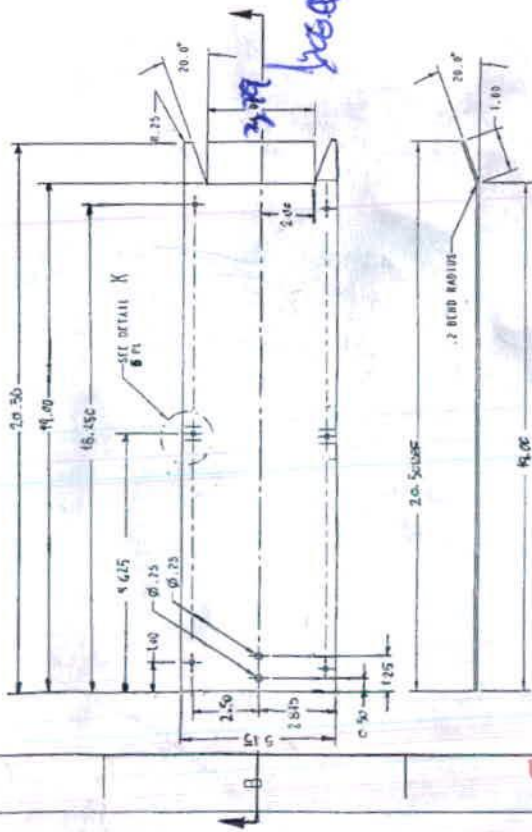
ORIGINAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41512

RELEASED
42



DETAIL K
SCALE 2.000
REF REF

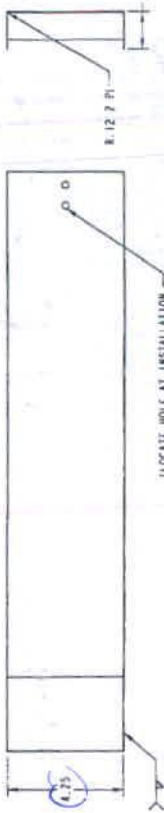


② - 159 SUPPORT PLATE
MATERIAL: 6061-T6, 00-A-250/11
SCALE 0.500

242-15 SYMMETRICAL ABOUT CENTER LINE



② - 73 20 DEGREE COVER PLATE
MATERIAL: 6061-T6, 00-A-250/11
SCALE 0.500



PREMIER AVIATION, INC.	
1000 Aviation Parkway, Grand Prairie, Texas 75050	
DATE: 08/11/88	BY: JLS
DESIGN: 00808	REV: 001
PROJECT: 867-43001	SHEET: 11 OF 15

ORIGINAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41512

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:27 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 41512

Part Number: PB674300171

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-install nut plates as per dwg B67-43001

8/08/09/24 (8)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/09/04 (8E)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *246*

8/9/04

(8x)

50

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/26

Job Completion



MF 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:27 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 41512

Part Number: PB674300171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counters
508/02/16 029

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1- weld as per dwg B67-43001

08.09.22 8

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-grind weld flush

08.09.24 8

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

BE
08.09.24

(XB)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/02/16 (XB)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

08/09/24

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 180.0000 Each(s)
Nutplate

M109068

08/09/24

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: 360.0000 Each(s)
RIVET

M105978

08/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-71 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/09/16
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41512</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/09/15</u>	<u>5</u>	<u>1 piece was was out of tolerance RC poor drawing</u>	<u>[Signature]</u>	<u>Scrap & destroy No Replue</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08/09/16</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08/09/16</u>

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:27 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT PLATE
Job Number	: 41512	Part Number	: PB674300171
Estimate Number	: 13385	Drawing Number	: B6743001 P.9/26
P.O. Number	:	Project Number	: N/A
This Issue	: 19/08/2008 S.O. No. :	Drawing Revision	: B1
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 18/09/2008
Previous Run	: 40244	Qty:	30 Um: Each
Written By	:		
Checked & Approved By	: <u>JLD 08.8.20</u>		
Comment	Est Rev:A 08-06-19 new issue DD verified by:ec Est Rev:B 08-06-27 procedure chg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S090	6061-T6 .090 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.8594 sf(s)/Unit Total : 25.7828 sf(s)
 6061-T6 .090 Sheet
 batch: 109184 IB 8-9-9

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001-159
 Dwg Rev: B1
 Prog Rev: B1 IB 8-9-9
 ****grain direction along 5.750" ****
 2-Deburr if necessary IB 8-9-9

(30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



POSITIVE RECALL

EFFECTIVE 08.09.09 AUTH if

RELEASED in DATE 08.09.10

Comment: SECOND CHECK



5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE 1- countersink as per dwg
 2- Bend as per Dwg B67-43001

2808/09/11 (30)
28 08/09/15 (29)

count

5006410 (+30)

Pro

(29)